

Work Order ID 136069

Friday, August 28, 2015 8:53:58 AM

136069

Page 1

Item ID: 647.7714

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Tube

Start Date: 8/28/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/4/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: mf. Date: 15-8-28

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7700	A

110

0.00

110

Mill Conv

Memo

0.02

Conventional Milling Machine

1- CUT AS PER DWG
2- Mill end of tube as per dwg
3- DEBURR AS PER DWG

12

0

J.C.L. 15/09/02

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12

0

J.C.L. 15/09/02

125

QC8- Inspect parts - second check

0.00

125

QC

Memo

0.00

Quality Control

12

0

DAS
44
9-89

15/09/02

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Page 2

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Setup Start

NS1

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Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: WA001

0.00

130

Packaging

Memo

0.00

Packaging

Stock in large fab
WA001

12

27

9-89

SEP 03 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

15/9/3

SW 20150903

Picklist Print

Friday, August 28, 2015 8:53:57 AM

Page 1

Work Order ID: 136069

136069

Parent Item: 647.7714

647 7714

Parent Item Name: Strut Tube

Start Date: 8/28/2015

Required Date: 9/4/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.500W.083		Purchased			No		f	18.9847		7.578947			

M4130NT0 500W 083

4130 RD tube .500 x .083W

Location

Loc Qty

Loc Code

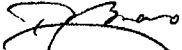
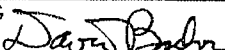
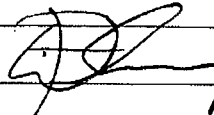
MAT032

18.9847

M132941

18.9847

7.005 J.C.L. 12/09/01

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 04741				SHEET 1 OF 1	
	DWG NO. 647.7700	REV: NC	PREPARED BY J. SOTO	DATE: 11/13/2014	EFFECT ON DWG ☒ INC. ☐ UNINC.	
	DWG TITLE: STRUT ASSY					
	APPROVED BY:	ENGR 	MFG 	QC 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE	REASON: CREATED NEW CONFIGURATION. ADDED F/N 5.					

MF
136069

5	A	647.7714	1	STRUT TUBE	△	
4	R	647.7713	1	STRUT THREAD	△	△
3	R	647.7712	1	STRUT TUBE	△	
	C	647.7703	X	STRUT ASSY		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION

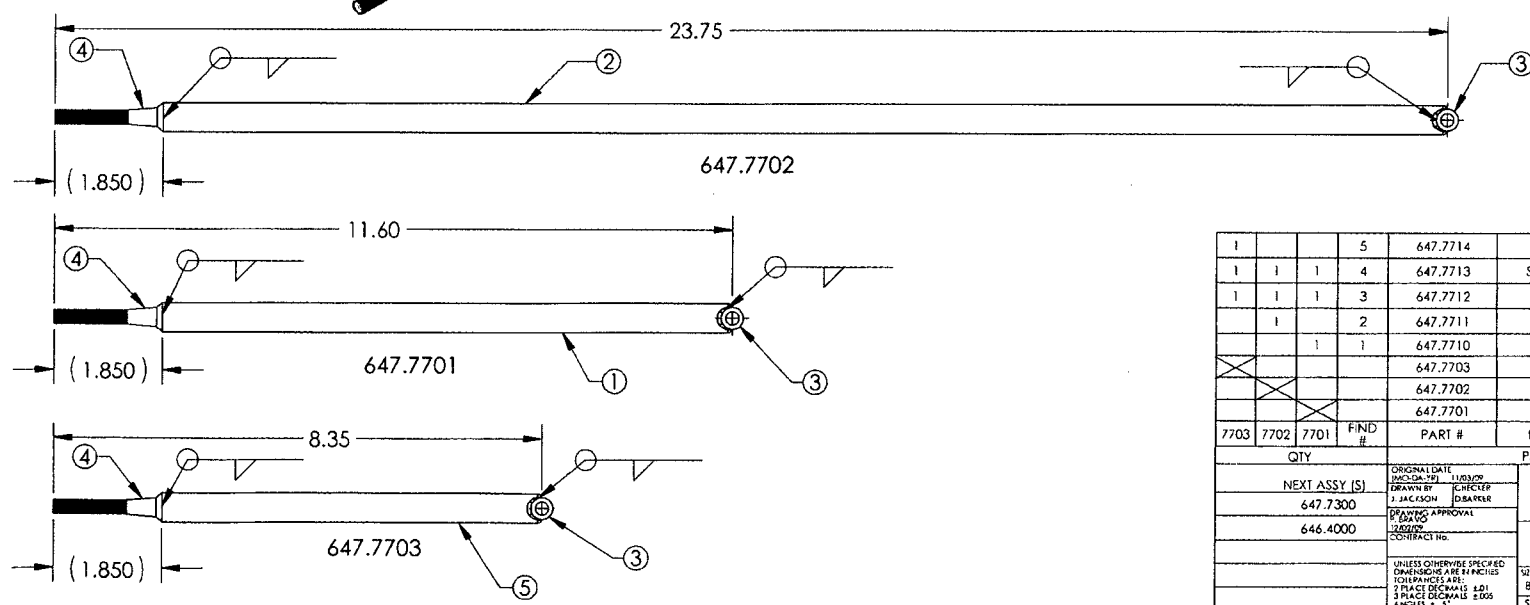
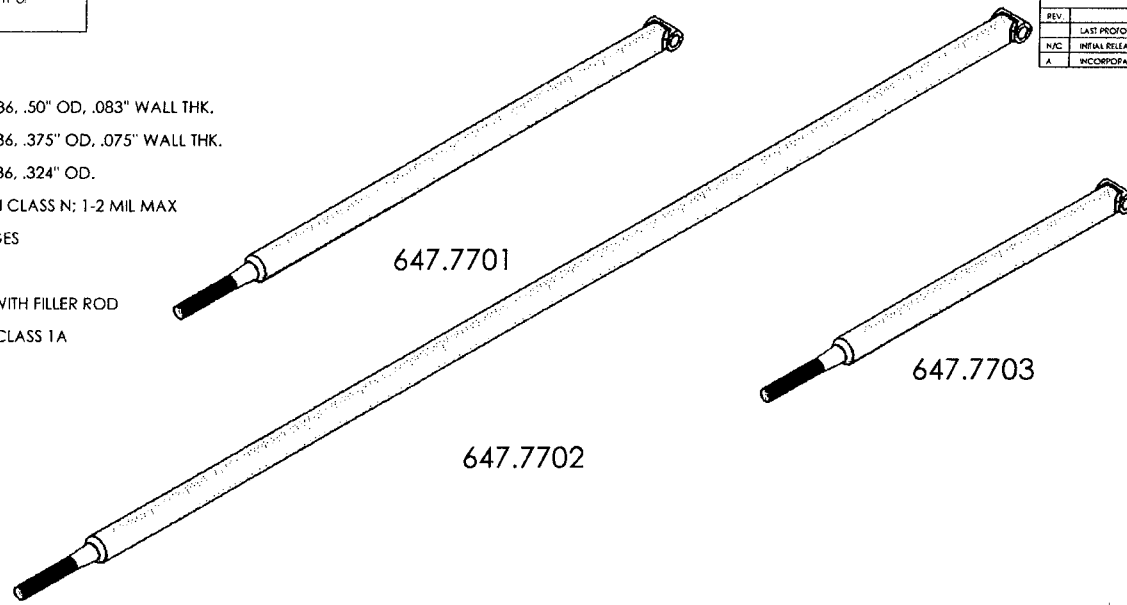
DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY	DER REVIEW REQUIRED
		☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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NOTES:

1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N: 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: P02		N/C
2	INITIAL RELEASE	12/02/09	P. BRAVO
3	INCORPORATED ICH 04/11	11/13/14	P. BRAVO



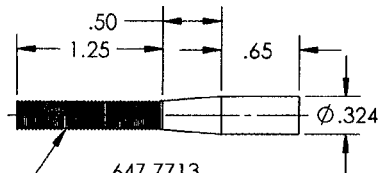
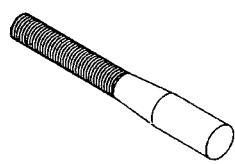
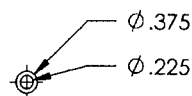
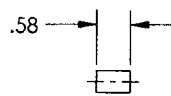
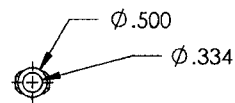
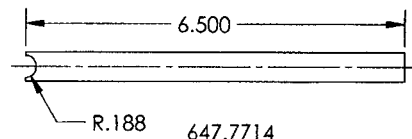
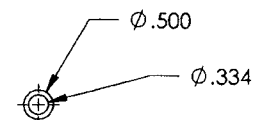
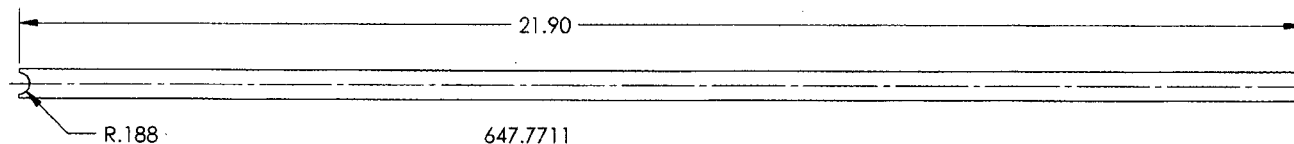
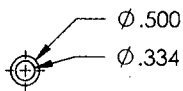
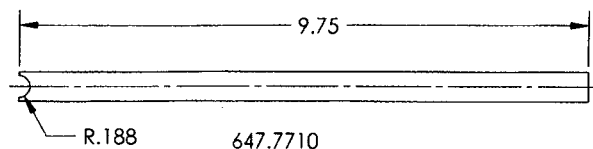
1	1	1	5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
	1		2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△△
				647.7702	STRUT ASSY		△△
				647.7701	STRUT ASSY		△△
7703	7702	7701	FINI #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE			
647.7300				DRAWN BY			
646.4000				F. JACKSON			
				CHECKED			
				DISAPPEAR			
				DRAWING APPROVAL			
				P. BRAVO			
				CONTRACT NO.			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				2 PLACE DECIMALS ±.01			
				3 PLACE DECIMALS ±.005			
				ANGLES ±.5°			
				SCALE: NONE			
				SHEET 1 OF 2			

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

STRUT ASSY

SIZE B 07M16 DWG NO. 647.7700 REV. A

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1/4 - 28 THREAD

ORIGINAL DATE INDUSTRIES		APICAL INDUSTRIES	
DRAWN BY J. JACKSON		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY P. BRAVO		STRUT ASSY	
CONTRACT NO.		REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 SPALLS DECIMALS ±.05 ANGLES ±.5°		SHEET B 07M16	DWG. NO. 647.7700
SCALE: NONE		SHEET 2 OF 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									